



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2666-1
Job Sheet 206081



Part No: D2666-1

Job Qty: 1 pcs

Part Name: Saddle, LH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/24/20

Job Tracking No:

Due Date: 1/31/20

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	1 pcs	1/31/20		0.00	0.91	HAAS - 1		SBL 20/01/24
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	1 pcs	1/31/20		0.00	1.12	Conventional Mill - 1 - B4B		SBL 20/01/24
							Conventional Mill - 2 - B4B		
120	QC 2	1 pcs	1/31/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S250280



Part: D2666-1

Job No: 206081

Serial No/Batch: S250280

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/24/20

					QC 2 - 57	SBL 20/01/24
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 8 - 12	
					QC 8 - 14	mk 20/01/24
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130 QC 8	1 pcs	1/31/20	0.00	0.00	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	★ JAN 24 2020
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
140 Handfinish - 1-1 Chemical-B4B	1 pcs	1/31/20	0.00	0.05		

			Handfinish - 1 - 21 - B4B		
			Handfinish - 1 - 22 - B4B		
150 Powdercoat - 1 White GI(A)- B4B 1/31/20	1 pcs	1/31/20	0.00 0.04	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				START: 8:25 CUT: 320° FINISH: 8:55	
160 QC 3	1 pcs	1/31/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
		JAN 29 2020			
170 Packaging 3-1 - Stock - B4B	1 pcs	1/31/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
		DAS 28 9-89			
			Plex 1/24/20 7:47 AM dart.lacelle.linda		

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	1 pcs	1/31/20	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - HAAS CNC Vertical Machine - Program batch number.
 Descriptions: 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

JAN 30 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	1 pcs (1 ea)	100-HAAS 4 Axis	S226781

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	1	49	0

Part Specifications
Specifications could not be found.

DART AEROSPACE LTD		Work Order: 200 081
Description: 206 Saddle, Inboard, Left side		Part Number: D2666-1
Inspection Dwg: D2666	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121				
B	0.100	0.140		.129				
C	2.470	2.510		2.495				
D	0.100	0.180		.140				
E	0.210	0.230		.220				
F	1.313	1.343		1.320				
G	0.240	0.260		.248				
H	0.615	0.685		.655				
I	1.125	1.145		1.135				
J	0.990	1.010		1.003				
K	0.235	0.240		.238				
L	0.510	0.515		.511				
M	0.100	0.120		.115				
N	1.565	1.585		1.575				
O	5.990	6.010		6.000				
P	1.245	1.255		1.250				
Q	2.495	2.505		2.500				
R	0.490	0.510		.499				
S	0.312	0.318		.312				
T	2.495	2.505		2.500				
U	1.357	1.367		1.362				
V	0.315	0.322		.310				
W	0.540	0.560		.549				
X	1.674	1.684		1.679				
Y	0.256	0.262		.258				
Z	0.178	0.198		.188				
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL	Date: 20/01/24
Audited by: MK	Date: 20/01/24
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	M